

SPUT

Dart Aerospace Ltd.

Date: Thursday, 16/08/2007 10:31:33 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 34010
 Estimate Number : 10794
 P.C. Number : N/A
 This Issue : 16/08/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LARGE FAB ASSY
 Previous Run : 32892

Drawing Name : TOW RING

Part Number : D3407041
 Drawing Number : D3407 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : N/A
 Due Date : 02/09/2007

Qty: 12 Um: Each

Written By :
 Checked & Approved By :
 Comment : Est Rev A 05.10.14 New issue KJ/EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D34071 Stem



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D3407-1 Stem 632898

JL 07/10/31

(2x)

2.0 D34075 Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D3407-5 Ring 34708

JL 07/10/31

(2x)

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D3407-3/-5 using welding rod TIG174 as per Dwg D3407 & QSI 004

A/R TIG174 ROD Batch: 18774

JL 07/10/31

(2x)

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

JL 07/10/31 (2)

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JL 07/10/31 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 09/01/31
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 10:31:33 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 34010

Part Number: D3407041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M105914



(2x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask Threaded Section

m-l/BR 07/10/31

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

U 07-10-31

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

U 07-10-31

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(2) 07/10/31

Job Completion



U 07-10-31

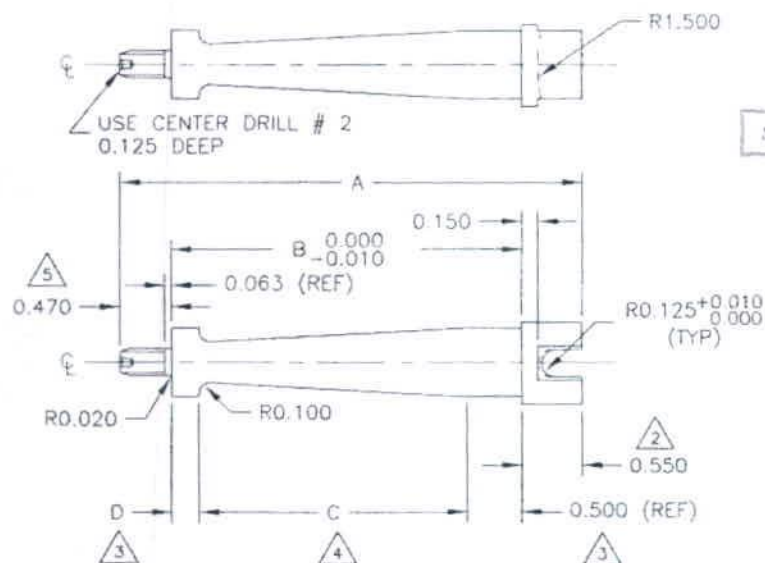
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

D3407-1/-3 STEM

D3407-1 AND D3407-3 STEM:

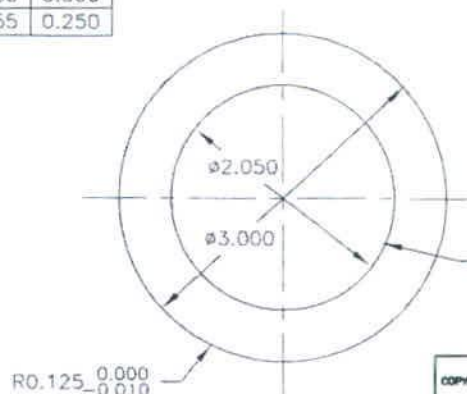
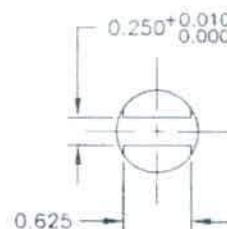
- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2) #0.750 O.D.
- 3) #0.625 O.D.
- 4) MACHINE UNIFORM TAPER FROM #0.363 O.D. TO #0.625 O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3407-5 RING:

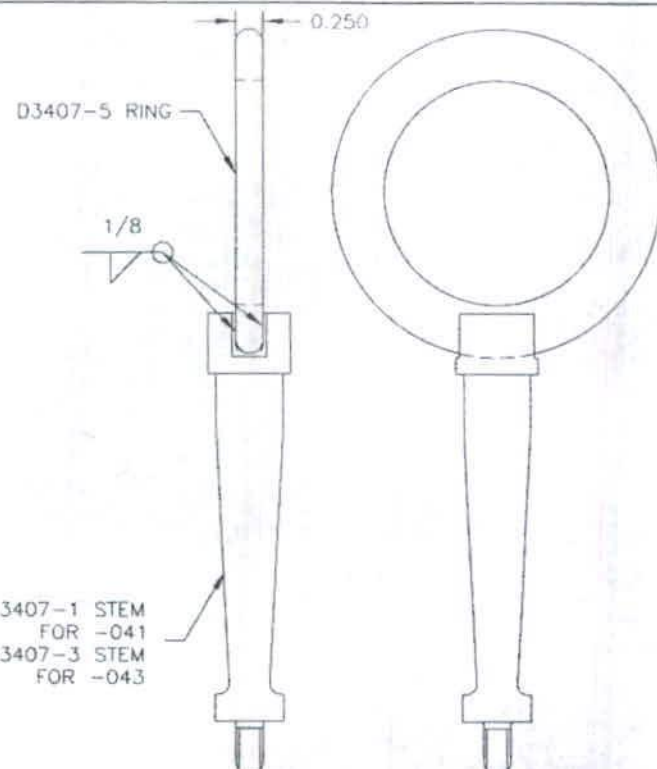
- 9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

DS 04.12



D3407-5 RING



USE D3407-1 STEM FOR -041
USE D3407-3 STEM FOR -043

D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEBURR 0.010 TO 0.020

C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	CP
CHECKED	✓	✓
APPROVED	✓	✓
DRAWING NO.	D3407	
DATE	05.09.09	
TITLE	TOW RING	

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DART DART AEROSPACE USA, INC.
PORT WILKINSON, PA

SHEET 1 OF 1

SCALE
1:1

04/09/09

